



Dart Aerospace Ltd.
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K6A 1K7
Canada

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D3167-1
Job Sheet 205828



Part No: D3167-1

Job Qty: 24 pcs

Part Name: Bearpaw



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/17/20

Job Tracking No:

Due Date: 2/21/20

Created By: Jennifer Renwick

Type: Stock

Description:

Note: DWG REV A1

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
120	Waterjet - Flow - 1	24 pcs	2/21/20	2/21/20	0.17	8.14	Waterjet - Flow	DAS 52	20/04/14
130	HAAS 4 Axis - B4B	24 pcs	2/21/20	2/21/20	1.00	39.34	HAAS - 1 - B4B	9-89	20/04/26
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
140	QC 2	24 pcs	2/21/20	2/21/20	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52	DAS 52	20/04/21
							QC 2 - 57	9-89	
							QC 2 - 62		
							QC 2 - 63		

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					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 2 - 76	
150	QC 8	24 pcs	2/21/20	0.00 0.00	QC 8 - 12	
					QC 8 - 14	7/20/04/27
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					QC 8 - 76	
					QC 8 - 61	
151	Packaging 3-1 - Stock - B4B	24 pcs	2/21/20	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	DAS
					Packaging 3 - 7 - B4B	28
					Packaging 3 - 8 - B4B	9-89
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	

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				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
190 QC 21 - SA				24 pcs	2/21/20
				0.00	0.00
				QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	

APR 29 2020

DAS

70

9-89

Part Op 120 - Cut Blank as per File D3167-1_BLANK
 Descriptions: 130 - (HAAS CNC Vertical Machine) Note: (2) Bearpaw for (1) Kit 2-Machine as per Folio FA285 and Dwg D3167
 140 - (QC2- Inspect parts off machine FAI/FAIB)
 150 - (QC8- Inspect parts - second check)
 151 - (Identify as per dwg & Stock Location: _____)
 190 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MUHMWB10	UHMW 1" Black - 48"x120" Tivar Mfg.#52480104	86.4000 sf (3.6 ea)	120-Waterjet - Flow - 1	5262128

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
120-Waterjet - Flow - 1	MUHMWB10	86	478	0

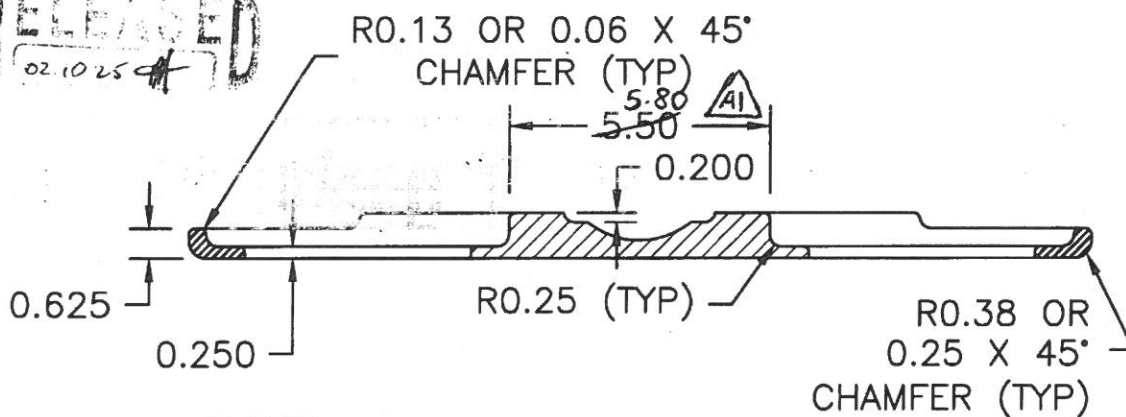
Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bearpaw	0.060inches + 0.030 - 0.010	0.090 0.050	0.06	
2	Bearpaw	45.000Degrees ± 0.500	45.500 44.500	45°	
3	Bearpaw	5.800inches ± 0.030	5.830 5.770	5.796	
4	Bearpaw	0.250inches ± 0.030	0.280 0.220	0.25	
5	Bearpaw	45.000Degrees ± 0.500	45.500 44.500	45°	
6	Bearpaw	0.250inches ± 0.030	0.280 0.220	0.25	Radius
7	Bearpaw	0.200inches ± 0.030	0.230 0.170	0.200	
8	Bearpaw	0.250inches ± 0.010	0.260 0.240	0.252	
9	Bearpaw	0.625inches ± 0.030	0.655 0.595	0.635	
10	Bearpaw	0.375inches ± 0.010	0.385 0.365	0.385	
11	Bearpaw	0.950inches + 0.030 - 0.010	0.980 0.940	0.960	
12	Bearpaw	3.210inches ± 0.030	3.240 3.180	3.210	
13	Bearpaw	19.000inches ± 0.030	19.030 18.970	19.0	
14	Bearpaw	0.260inches ± 0.005	0.265 0.255	0.26	Diameter
15	Bearpaw	0.930inches ± 0.030	0.960 0.900	0.93	Diameter
16	Bearpaw	0.300inches + 0.030 - 0.000	0.330 0.300	0.315	
17	Bearpaw	0.375inches ± 0.030	0.405 0.345	0.375	
18	Bearpaw	7.230inches ± 0.030	7.260 7.200	7.230	
19	Bearpaw	4.540inches ± 0.010	4.550 4.530	4.540	
20	Bearpaw	2.000inches ± 0.030	2.030 1.970	2.000	
21	Bearpaw	12.000inches ± 0.010	12.010 11.990	12.000	
22	Bearpaw	6.000inches ± 0.010	6.010 5.990	6.000	
23	Bearpaw	23.750inches ± 0.030	23.780 23.720	23.75	

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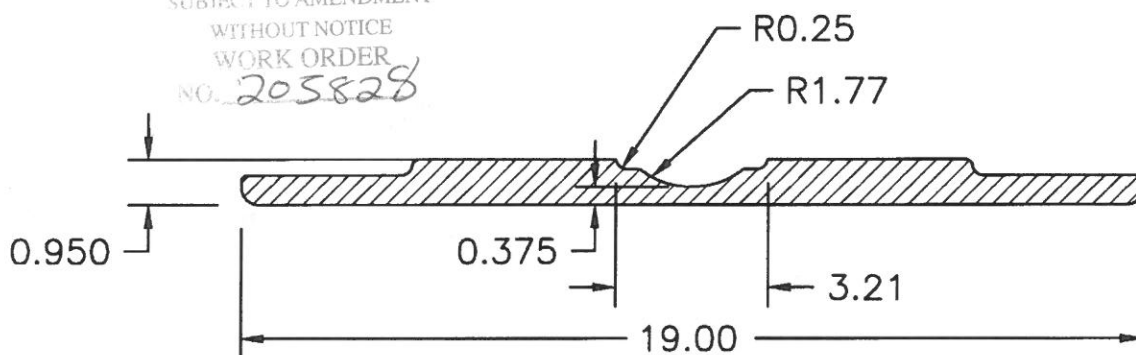
DESIGN 	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3167	REV. A SHEET 2 OF 2
DATE 02.10.08		TITLE BEARPAW	SCALE 1:4

RELEASED
02.10.25

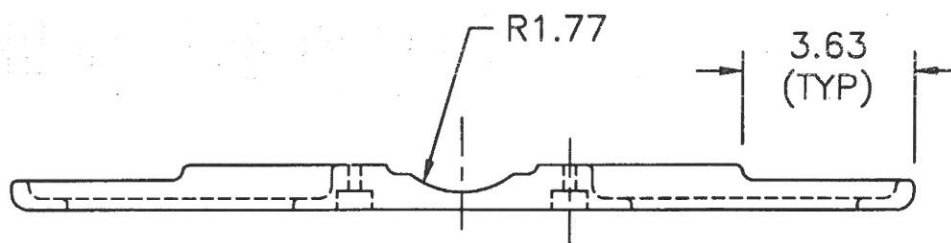


SECTION A-A

SHOP COPY
RETURN TO
ENGINEERING
(UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 205828)



SECTION B-B



SECTION C-C

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Entered: _____

Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION		DEPARTMENT/PROCESS	
		Rework ☐ Scrap ☐ Use-as-is ☐		Cross tube ☐ Small Fab ☐ Finishing ☐ Skid-tube ☐ Machining ☐ Large Fab ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐	
Date: _____	Sequence #: _____	QTY Affected: _____		MRB (QS1042)	
Description Work Order Deviation		Disposition			
Root Cause		FAULT CATEGORY			
Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____			
		Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐			
		Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐			
		Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐			